

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019110**Date Inspected:** 08-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of critical repair (R3) weld is identified as 3G-001 of SB024-108 for SB108 West. The welder is identified as 062761. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and CWR-02732.

FCAW welding of critical repair (R3) weld is identified as 3G-026of SB024-108 for SB108 West. The welder is identified as 062761. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-FCAW-3G-ESAB-Repair and CWR-02732.

FCAW welding of weld is identified as 2G-002 of BK004B8-001 for BK004B-001. The welder is identified as 062806. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2232-ESAB.

FCAW welding of weld is identified as 3G-130 of BK005A8-002 for BK005A-002. The welder is identified as 062749. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

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ZPMC personnel performing Re-Heat straightening of Suspender bracket is identified as SB108 East after ZPMC QC personnel performed their UToF welds, this is informed to ZPMC QC Mr.Xu tao to perform Re-UT of those welds.

SMAW welding of weld is identified as 1G-003 of BK5ASD1-002 for BK005A-002. The welder is identified as 259566. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4c.

SMAW welding of weld is identified as 1G-023 of BK5ASD1-002 for BK005A-002. The welder is identified as 259566. ZPMC QC is identified as Mr.Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-P-2211-Tc-U4c.

Fourth time reject able indications found ZPMC QC NDT personnel in suspender bracket is identified as SB104West, the weld no are SB022-104-002,004,006,005.

Third time reject able indications found by ZPMC QC NDT personnel in suspender bracket is identified as SB106 West, the weld no are SB022-106-002,006,005,015,013. Informed to ZPMC QC Mr. Xu tao to make CWR before go to repair.

Green tag issued to following suspender bracket after NDT and VT carried out successfully.

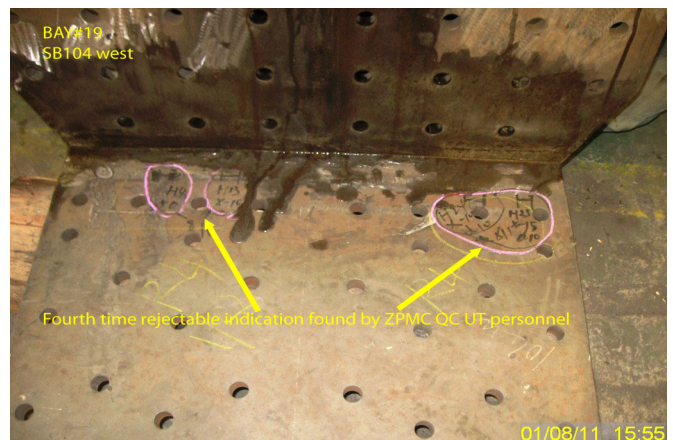
SB110E – Step I -014963.

SB110w- Step I -014961.

SB104E – Step II -015002.

SB104E - Step I (after Repair Re-Tag)-012254.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Chadra

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer